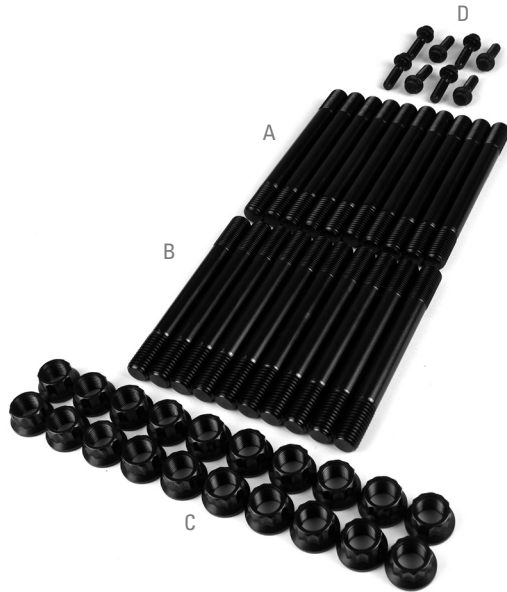




PART NO. XD3003MS
XDP MAIN STUD KIT

INSTALLATION MANUAL



CODE	DESCRIPTION	QTY
A	5.645" Main Stud	10
B	5.165" Main Stud	10
C	Nut	20
D	M8 Bolt	8



BEFORE REMOVING ANY PARTS FROM YOUR TRUCK, PLEASE COMPARE THE ITEMS YOU HAVE RECEIVED WITH THE PACKING LIST PROVIDED TO VERIFY THAT YOU HAVE EVERYTHING NECESSARY TO INSTALL YOUR NEW XDP MAIN STUD KIT.



BEFORE YOU BEGIN! Ensure that the vehicle has not been in use and that the engine is cool to the touch. Always wear eye protection when working on any vehicle.

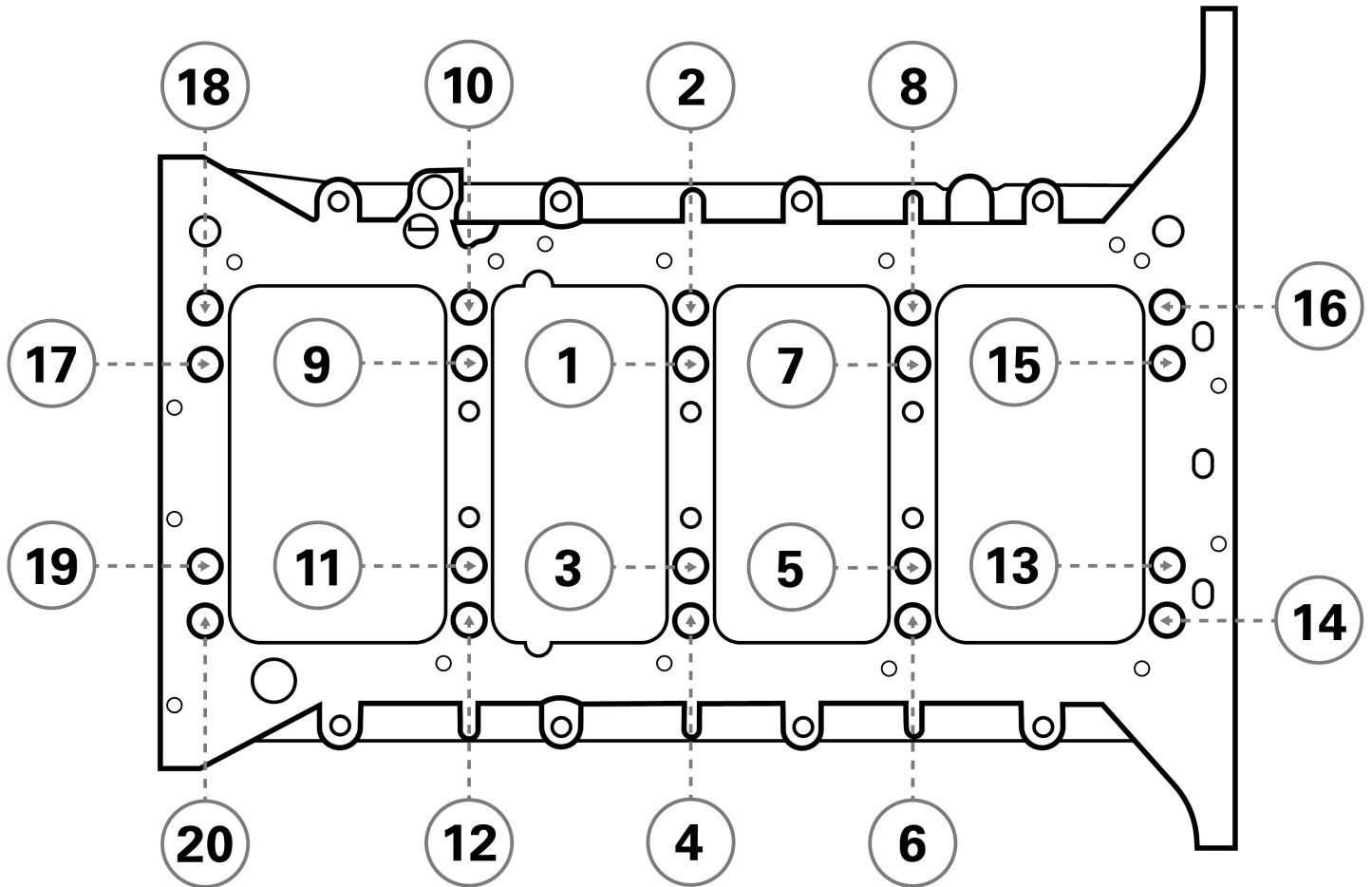
- 1 Clean all threads in the block using a thread cleaning chaser such as XD40126TC & XD40128TC to ensure proper thread engagement and accurate torque readings.
- 2 Clean and inspect all hardware before installing to ensure it is clean and free of shipping damages.
- 3 Install the studs into the block **HAND TIGHT!** **NOTE:** Inner studs are 5.645" in length, and the Outer studs are 5.165" in length.
- 4 Proceed to install the main caps and check for any clearance issues or binding.
- 5 Lubricate the stud threads and nut threads with assembly lubricant such as XD541 X-TRA Slick Engine & Fastener Assembly Lubricant (sold separately).

6 Following the torque sequence below tighten the nuts and bolts in three equal steps.

7 1st pass 60ft lbs (Studs 1-20) 2nd pass 120 ft lbs (Studs 1-20) Final pass 180ft lbs (Studs 1-20) and then torque the M8 bolts to 25 ft lbs (21-28)

TORQUE SEQUENCE

1ST PASS → **2ND PASS** → **FINAL STUD PASS** → **M8 BOLTS**
60FT LBS → **120FT LBS** → **180FT LBS** → **25FT LBS**



NOTE: After installation it is required to inspect the main bearing bores for proper size, and any out of round conditions as clamping force and tolerances will change. If necessary, align hone the engine block. Main bores should be align honed using the same fasteners and lubricant that is being used during final assembly. Modification to the oil pan adapter may be required. Check the top of the main studs for proper clearance and modify the adapter if necessary.